

Work Order ID 67151

Wednesday, March 09, 2011 12:49:56 PM



Page 1

Item ID: D206-642-341

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 3/9/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/18/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

11-03-9

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2650

F

100

0.00



DOCUMENT CONTROL

DC

0.00

Memo

Document Control

Photocopy bluefile and create labels per PPP D206-642-341 CHG003

N/A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 	Skidtubes	0.00							
Skidtubes	Memo	0.00							
Skidtubes	1-Deburr Fwd edge of tube								
	2-Remove ridge on inside of Fwd edge of tube as per Dwg D2650								
	3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required. A/R <input type="checkbox"/> Aluminum Rod <input checked="" type="checkbox"/> M11385/M116577								
	4-Grind weld flush to cap on top surface only.								
	5-Cut aft end to length as per dwg D2650								
	6-Drill pilot holes using drill Jig DT8168A (A,& B) and DT8025. Open to Ø0.312"								
	7-Drill holes for wearplates using DT 8028-5. Open to Ø 0.297".								
	8-Open Aft Cap Hole using #6 Drill Bit								
	9-Open holes for Tow Ring to Ø0.625" as per Dwg D2650, D2650-5 Drilling Detail								
	10-Remove inner indexing ridge on aft end of skidtube as per Dwg D2650								
	11-Deburr and Blow out all chips from inside the tube								

11-4-6

BE 11/04/07

BE 11/04/08

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Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

115

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

120

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

125

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

Sulaylos

40

N

BB 11/04/08

DP

11-4-8

W/O:		WORK ORDER CHANGES					
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Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

0.00



Skidtubes

0.00

Skidtubes

Memo1-Open holes to finished size as per Dwg D2650, D2650-5 Drilling Detail
(without cutting fluid)

2-Countersink crossbolt spacer holes as per Dwg D2650(without cutting fluid)

3-Deburr. Blow out chips. Grind alodine off around crossbolt spacer.

4-Bond D2654-5 web in place as per QSI 015 Ensure holes line up Allow 12 Hrs.
cure time before cutting ☐Start Date: 11-4-8 ☐ Time: ☐ 320 ☐Finish Date: _____ ☐ Time: ☐A/R ☐ Sikaflex-291 ☐ 11/10/98 ☐Sikaflex expiry date: ☐ 12-31-16 ☐

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

11-4-8

1 0 BE 11/04/11

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

0.00



Skidtubes

Skidtubes

Memo

0.00

1-Prep per QSI 005 and Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.
A/R ☐ Aluminum Rod ☒ *M111385 BE 11/04/14*

2-Grind welds flush as per Dwg D2650. Masking Tape access to inside of the Skidtube

3-Counterbore 5/16" x 0.750" deep as per Dwg D2650 Debur

4- Install nut plate as per dwg

170

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

*Sub 4/10**BE 11/04/14**10*

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Customer:

Reference:

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



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--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

180

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

190

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

Brush alodine tube on crossbolt spacer area, do not acid etch, do not dip tube in tank.

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 8:45
OVEN TEMPERATURE: 320°
FINISH TIME: 9:15

1 of 11-4-19

1 BL 11-4-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Customer:

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 0 HL 1104/21

W/O:		WORK ORDER CHANGES					
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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

220

0.00



HandFinishing

HandFinish

Memo

0.00

Hand Finishing

1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside
insert holes before installing wearpad/wearplate.A/R ☐ Sikaflex-291 ☐ M116198 ☐Sikaflex expiry date: ☐ 12/012-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install
plugs as per Dwg D2650. Clean excess adhesive

3-Install MS27039-4-06 Screw as per DEO 9153

4-Inspect for foreign object per QSI 024

5-Install D2646 Aft Cap and seal with SikaflexClean excess adhesive

A/R ☐ Sikaflex-291 ☐ M116199 ☐Sikaflex expiry date: ☐ 12/01

6-Wing Walk as per Dwg D2650-5 and QSI 005 4.4

Batch: M117315

1	0	11	1104/21
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W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

230

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

nl 11 04 26 ①

240

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

nl 11 04 26 ①

250

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D206-642-341

Location:

PPP Rev:

P17267686

Pack 5/11 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

260

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/11 [Signature]
ME
11-05-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

Wednesday, March 09, 2011 12:50:01 PM

Page 1

Work Order ID: 67151

Parent Item: D206-642-341

Parent Item Name: Replacement Skidtube



Start Date: 3/9/2011

Required Date: 3/18/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: H 05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM
 IPP Rev: I 08-09-29 revF as per dwg DD verified by: EC Est Rev: J 09-03-02 as per DS19440 rev.a DD verified by: EC IPP rev K 10.08.03 chg ms27039-1-08 for "C" type EC verified by DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN960JD416 NAS1149D0463J Purchased

No

Each

30.0000

1



Washer



JL 11/04/11

Location

Loc Qty

Loc Code

ST300

24

M116805

XL

113288

24

ST356

6

115622

6

CCR264SS3-3

Purchased

No

Each

332.0000

2



Cherry Rivet



BE 11/04/11

Location

Loc Qty

Loc Code

ST311

332

112314

4

113539

44

113973

88

117086

196

2

W/O:		WORK ORDER CHANGES					
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Parent Item: D206-642-341

Parent Item Name: Replacement Skidtube

Start Date: 3/9/2011

Required Date: 3/18/2011

Start Qty: 1.00

Required Qty: 1.00

CR3212-4-03

Purchased

No

Each

1,837.000

2



Cherry Rivet



BE 11/04/11

Location

Loc Qty

Loc Code

MEZZ

1837

110139

2

110153

35

111359

5

112314

2

114436

448

114450

31

114859

1314

2

D2620

Manufactured

No

Each

15.0000

1



Skidtube, 206 Skidtube



Location

Loc Qty

Loc Code

LG

15

62684

6

64784

9

D2647

Manufactured

No

Each

51.0000

1



Cap



Location

Loc Qty

Loc Code

FP

51

55352

51

1

11-4-6
BE 11/04/11

Wednesday, March 09, 2011 12:50:01 PM

Shop Packet Print

Page 2

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Start Date: 3/9/2011

Required Date: 3/18/2011

Start Qty: 1.00

Required Qty: 1.00

D2649

Manufactured No

Each

120.0000

19



Cross Bolt Spacer

Location

Loc Qty

Loc Code

LG

120

58545

2

60652

4

61496

2

62889

11

63359

3

65317

98



BE 10/4/14
B68224 *19

D2654-5

Manufactured No

Each

2.0000

1



Web

Location

Loc Qty

Loc Code

LG

2

64878

2

Each

14.0000

1

D2680-041

Manufactured No



Nut Plate

Location

Loc Qty

Loc Code

ST020

14

55366

14



11-4-8
BE 10/4/14

Wednesday, March 09, 2011 12:50:01 PM

Shop Packet Print

Page 3

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Start Date: 3/9/2011

Required Date: 3/18/2011

Start Qty: 1.00

Required Qty: 1.00

MS27039C1-08

Purchased

No

Each

959.0000

56



SCREW



56
JL 11/04/21

Location

Loc Qty

Loc Code

FP

63

115336

63

ST293

896

115589

347

116022

148

116373

400

19185

1

X56

ALS4-1032-130

Purchased

No

220

Each

759.0000

54

54



Insert



54
JL 11/04/21

Location

Loc Qty

Loc Code

PKG11

624

114723

42

116864

582

ST282

96

110511

10

115911

86

M116800

X54

ST381

39

114654

39

AN960C10L

NAS1149C0332

Purchased

No

220

Each

61.0000

54

54



washer



54
JL 11/04/21

Location

Loc Qty

Loc Code

ST297

61

107534

59

108246

2

M117291

X54

W/O:		WORK ORDER CHANGES					
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Parent Item: D206-642-341

Parent Item Name: Replacement Skidtube

Start Date: 3/9/2011

Required Date: 3/18/2011

Start Qty: 1.00

Required Qty: 1.00

AN960JD10L NAS1149D0332J Purchased No

220 Each

4.0000 2 2



Washer

32 11/04/21

Location

Loc Qty

Loc Code

ST335

4

M117241

X2

11912

4

D2646 Manufactured No

220 Each

71.0000 1 1



Aft Cap

32 11/04/21

Location

Loc Qty

Loc Code

FP-4

1

57332

1

FP6

16

52663

3

62678

12

63633

1

X1

Return 2010

54

62678

54

D2651-1 Manufactured No

220 Each

511.0000 14 14



Plug

32 11/04/21

Location

Loc Qty

Loc Code

FP

189

51530

152

62638

37

fpa

322

53349

205

57869

117

X14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, March 09, 2011 12:50:01 PM

Work Order ID: 67151

Parent Item: D206-642-341

Parent Item Name: Replacement Skidtube

Start Date: 3/9/2011

Required Date: 3/18/2011

Start Qty: 1.00

Required Qty: 1.00

D2651-3 Manufactured No 220 Each 404.0000 14 14



O-Ring



Handwritten: 14 4/10/12

Location

Loc Qty

Loc Code

FP

404

46114

12

61962

392

Handwritten: x14

D3535-11 Manufactured No 220 Each 7.0000 1 1



Wearshoe



Handwritten: 1 4/10/12

Location

Loc Qty

Loc Code

FP019

7

57261

1

63676

6

Handwritten: x1

D3535-23 Manufactured No 220 Each 18.0000 1 1



Wearshoe



Handwritten: 1 4/10/12

Location

Loc Qty

Loc Code

FP021

18

63571

4

66236

13

Handwritten: x1

D3535-35 Manufactured No 220 Each 12.0000 1 1



Wearshoe



Handwritten: 1 4/10/12

Location

Loc Qty

Loc Code

FP018

12

65926

12

Handwritten: x1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 7

Wednesday, March 09, 2011 12:50:01 PM

Work Order ID: 67151

Parent Item: D206-642-341



Parent Item Name: Replacement Skidtube

Start Date: 3/9/2011

Required Date: 3/18/2011



Start Qty: 1.00

Required Qty: 1.00

D3536-11	Manufactured	No	220	Each	19.0000	1	1
							<u>yl ul04/21</u>



Gasket

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP011	15	
57867	3	<u>yl</u>
65574	12	
ST497A	4	
46715	4	

D3536-23	Manufactured	No	220	Each	36.0000	1	1
							<u>yl ul04/21</u>

Gasket

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP011	26	
63570	1	
66560	25	
ST	10	
66240	10	<u>yl</u>

D3536-35	Manufactured	No	220	Each	16.0000	1	1
							<u>yl ul04/21</u>

Gasket

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP012	16	
58683	1	
63579	1	
65573	2	
66237	12	<u>yl</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, March 09, 2011 12:50:02 PM

Work Order ID: 67151

Parent Item: D206-642-341



Parent Item Name: Replacement Skidtube

Start Date: 3/9/2011

Required Date: 3/18/2011

Start Qty: 1.00

Required Qty: 1.00

D3537-1	Manufactured	No	220	Each	29.0000	6	6
							<u>36 1104121</u>
Wearpad							

Location

Loc Qty

Loc Code

FP017

29

B66935



x6

37749

6

65057

23

D3537-3	Manufactured	No	220	Each	26.0000	1	1
							<u>36 1104121</u>
Wearpad							

Location

Loc Qty

Loc Code



FP17

26

65929

26

x1

MS27039-4-06	Purchased	No	220	Each	91.0000	1	1
							<u>36 1104121</u>
Screw							

Location

Loc Qty

Loc Code

ST292

91

109061

4

115460

87

x1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -1	QTY -3	QTY -5	QTY -7	PART NUMBER	DESCRIPTION
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
17	18	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET

F

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 67/51
PL 11-03-9

RELEASED
08-07-23

F

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 10) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 11) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- 12) DRILL 20.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- 13) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. ALL SECTION AND DETAIL VIEWS TRANSFERRED TO SHT 6. SHT 1 IN PL PART D2649 QTY UPDATED. SHT 6 SECT C-C GRIND INSTRUCTIONS DELETED FROM NOTE 7 (SEE NCR 239).	AJS	08.08.08
E	RMOVE CBORE, CHG DRILL, ADD CHAMFER	CP	06.03.30
D	REDRAW; INCORP. DE09136/9153/9163 MOD GROUND HANDLING ON D2650-1/-3	CP	04.05.17
C	CHANGE HOLE PATTERN AND FRONT END	DS	97.10.29
B	AS MANUFACTURED CHANGES	DS	97.06.26
A	NEW ISSUE	DS	97.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 1 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
DATE	08.08.08	COPYRIGHT © 1997 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC	

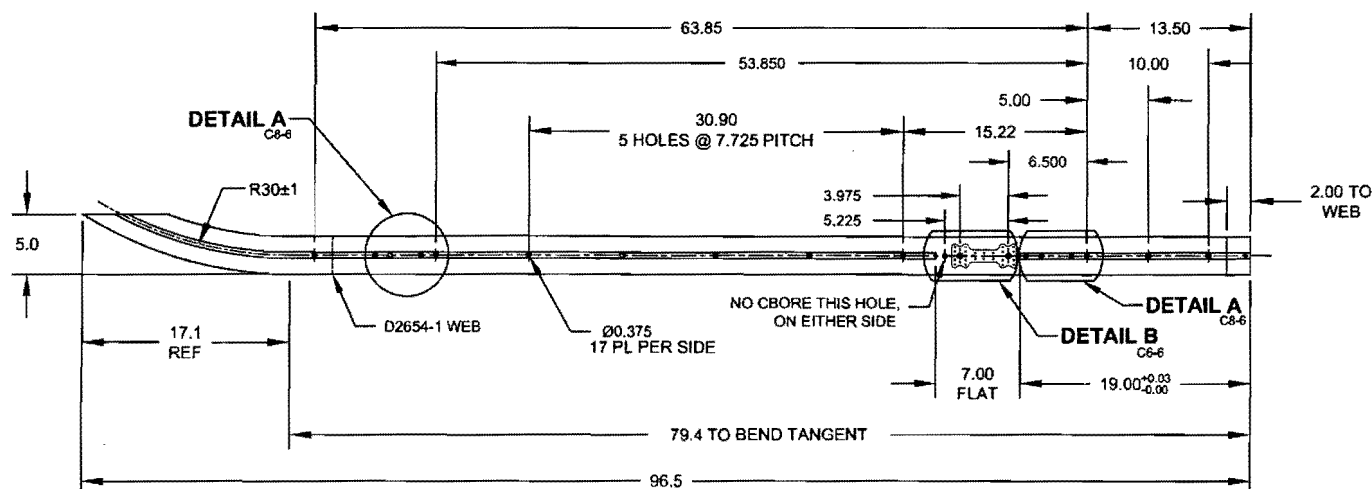
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

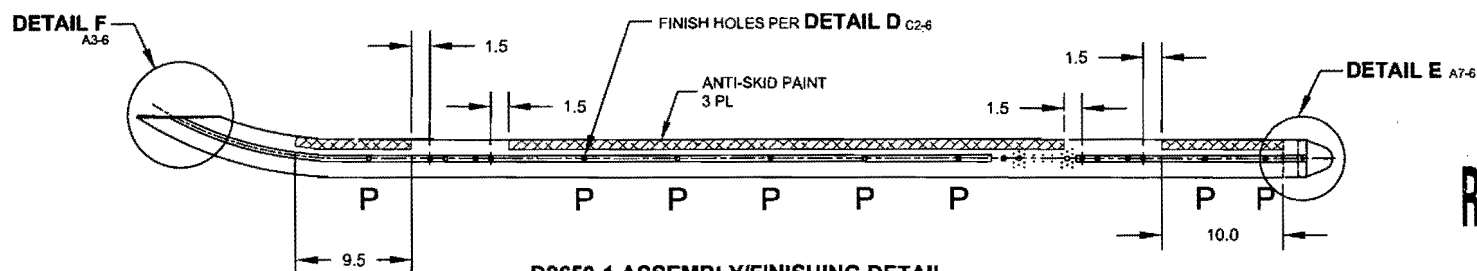
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2650-1 BENDING/DRILLING DETAIL



D2650-1 ASSEMBLY/FINISHING DETAIL

DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 2 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
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6807-22/111

u/b 67151

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

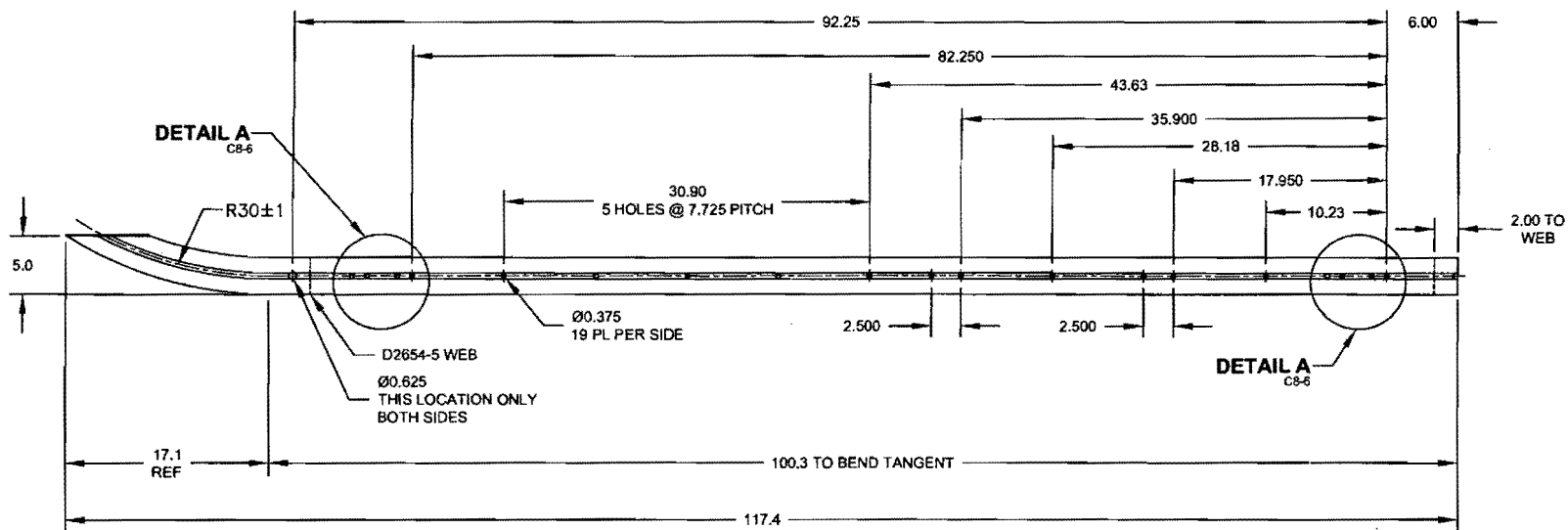
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

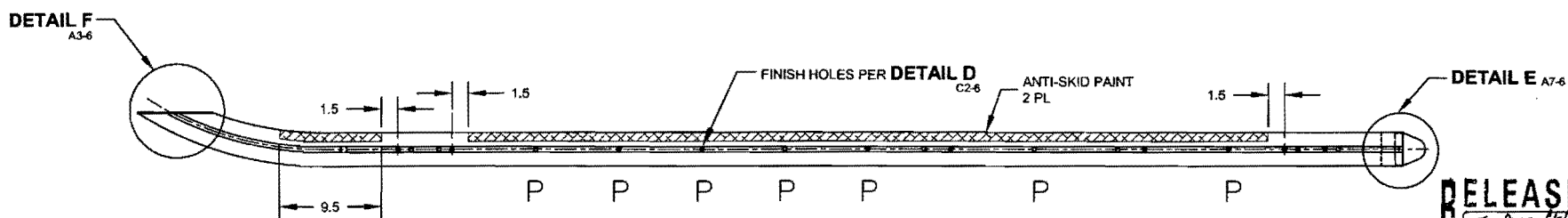
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2650-5 BENDING/DRILLING DETAIL



D2650-5 ASSEMBLY/FINISHING DETAIL

DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 4 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
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u/o 67151

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

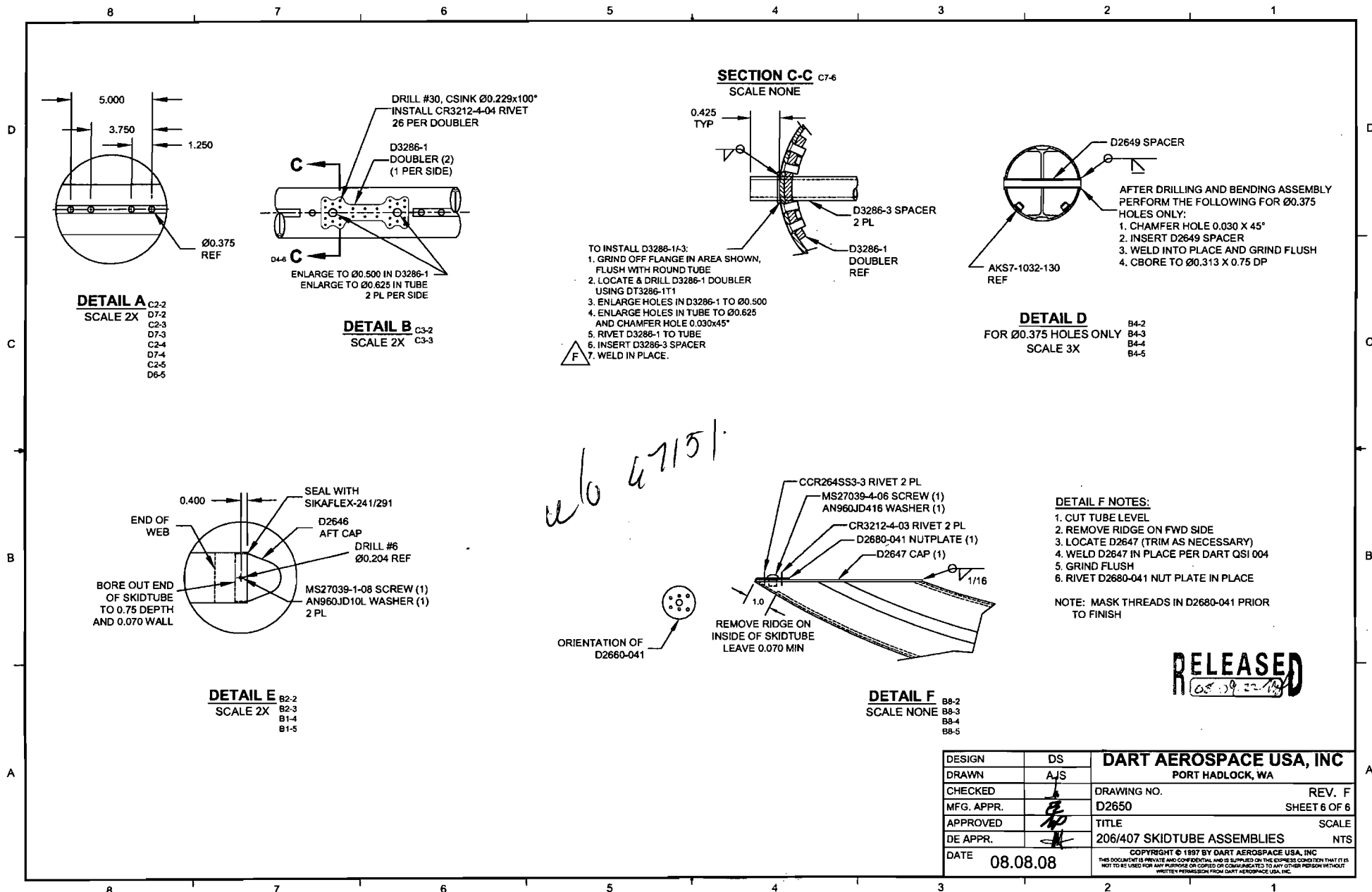
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 246

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barkley Elliott
Job number: 66462
Part number: D206-642-441
Description: 206 skid tube
Welding Process: Tig[☒] Mig[]
Base material: aluminum
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier Pat Lums Date of Test Coupon 11-03-09
Welder Barkley Elliott Date of Test Coupon 11-03-09

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

